

# Atlas 6" Backgeared Screwcutting LATHE



- ★ 6" swing, 18" capacity between centers
- ★ Headstock spindle is equipped with Timken tapered roller bearings for accuracy, service and versatility
- ★ Bed ways are massive, precision ground grey-iron for accuracy and rugged strength
- ★ The 16 spindle speeds equip you to handle a wide work range
- ★ Back gears provide extra power for heavy cuts
- ★ Reversible automatic longitudinal power feed cuts operating time
- ★ Complete V-belt drive
- ★ Wide thread cutting range — 8 to 96 Standard, right or left hand — Metric, .5 to 3 mm., Standard.
- ★ Operates from a 1/4 or 1/2 HP motor.

**No. 618 6" BACKGEARED SCREW-CUTTING LATHE.** Complete as shown, less motor, with equipment listed below. Code YEDUP, shipping weight 100 lbs.

## EQUIPMENT FURNISHED

Reversible Automatic Power Longitudinal Feed; Graduated Compound Rest; Tool Post, Ring and Ratchet, 3/8" Tool Bit; Complete Set of Change Gears to cut standard threads between 8 and 96 per inch; Threading Chart, Threading Dial; Quick-Change Countershaft; Complete V-Belt Drive; Motor Pulley furnished is for 3/4" diameter motor shaft — dealer can supply bushings for 1/2" dia. motor shafts; 60-Hole Indexing Mechanism; 5/16" Combination Metal and Wood-working Face Plate; Two 60° Lathe Centers — No. 2 Morse Taper for Headstock, No. 1 Morse Taper for Tailstock; 5 Wrenches; Instruction Manual.

## WIDE THREADING RANGE



Atlas 6-inch lathes are equipped with change gears and threading dial for cutting all threads from 8 to 96 per inch, right or left hand, in the following standards: National Coarse (UNC), National Fine (UNF), Acme, Square, and Whitworth. Gear train is completely enclosed — threading chart mounted on inside of guard shows gear train set-ups.

## SPECIFICATIONS

### CAPACITY

|                               |                                                                     |
|-------------------------------|---------------------------------------------------------------------|
| Swing Over Bed.....           | 6"                                                                  |
| Swing Over Carriage.....      | 3 1/2"                                                              |
| Capacity between Centers..... | 18"                                                                 |
| Threading Range.....          | 8 to 96 Standard, Right or Left Hand — Metric, .5 to 3 mm. Standard |
| Collet Capacity.....          | 9/32" (see page 14)                                                 |
| Overall Dimensions.....       | 35 1/2" x 27" x 12" high                                            |

### SPEEDS AND FEEDS

|                                                      |                                                                                       |
|------------------------------------------------------|---------------------------------------------------------------------------------------|
| Sixteen Speeds.....                                  | 54, 82, 122, 140, 187, 287, 317, 365, 481, 550, 820, 940, 1250, 1925, 2125, 3225 RPM. |
| Feeds (Left or Right) per Revolution of Spindle..... | .0078", .0048", .0039" or .0024"                                                      |
| Lead Screw.....                                      | 1/2" Diam., 16 Acme Threads per inch                                                  |

### DRIVE UNIT

|                                    |                         |
|------------------------------------|-------------------------|
| Motor Recommended.....             | 1/4 or 1/2 HP, 1725 RPM |
| Motor Mounting.....                | Bench                   |
| Countershaft Spindle Bearings..... | Oilite Bronze           |

### HEADSTOCK

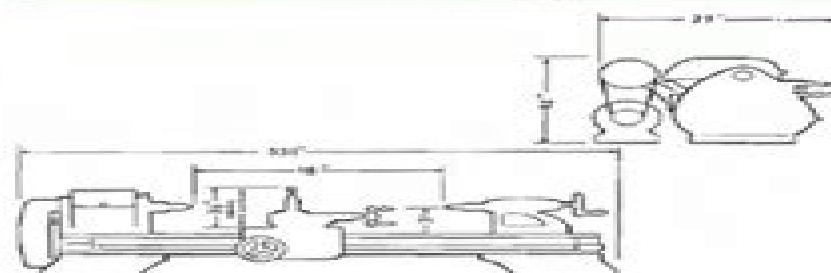
|                              |                                                                   |
|------------------------------|-------------------------------------------------------------------|
| Spindle Bearings.....        | Timken Tapered Roller Bearings with Thrust Take-up Collar and Nut |
| Spindle Nose.....            | 1" Diameter, 10 Pitch NS Threads                                  |
| Spindle Nose Taper.....      | No. 2 Morse Taper                                                 |
| Hole through Spindle.....    | 17/32"                                                            |
| Back Gears.....              | 20 Pitch, 3/8" Wide                                               |
| Backgear Shaft Bearings..... | Oilite Bronze                                                     |
| Spindle Gear.....            | 24 Pitch, 32 Teeth, 7/16" Wide                                    |

### CARRIAGE

|                             |                                                                    |
|-----------------------------|--------------------------------------------------------------------|
| Cross Feed Travel.....      | 4 3/4"                                                             |
| Cross Feed Screw.....       | 3/8" Diameter, Acme Thread                                         |
| Tool Post Slide Travel..... | 1 3/8"                                                             |
| Tool Post.....              | 13/32" x 3/4" slot to take 3/8" bits or tool holder for 3/16" bits |

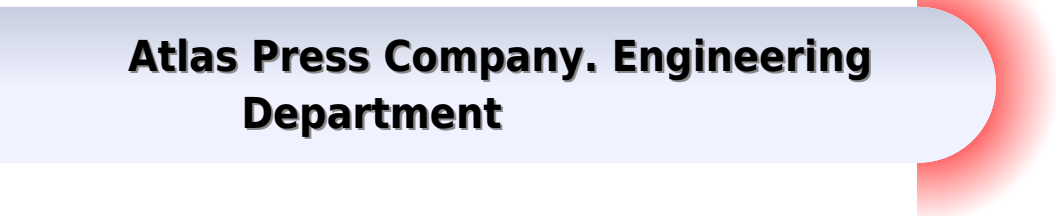
### TAILSTOCK

|                                          |                                        |
|------------------------------------------|----------------------------------------|
| Tailstock Ram.....                       | 3/4" Diam. Bored for No. 1 Morse Taper |
| Tailstock Ram Travel.....                | 1 1/4"                                 |
| Tailstock Set-Over, Forward or Back..... | 9/16"                                  |



# Atlas Lathe Operations Manual

**Atlas Press Company. Engineering  
Department**



## **Atlas Lathe Operations Manual:**

Manual of Lathe Operation and Machinists Tables Atlas Press Company. Engineering Department, 1937      *Manual of Lathe Operation and Machinists Tables* Atlas Press Company, Kalamazoo, Mich, 1937      **Engine Lathe Operations** Graham G. Whipple, Anthony C. Baudek, 1942      **Manual of Lathe Operation and Machinists Tables** Atlas Press Company, 1967

**Popular Mechanics**, 1937-03 Popular Mechanics inspires instructs and influences readers to help them master the modern world Whether it s practical DIY home improvement tips gadgets and digital technology information on the newest cars or the latest breakthroughs in science PM is the ultimate guide to our high tech lifestyle      **Manual of Lathe Operation and Machinists Tables** Atlas Press Company, 1937      **Circular** United States. Office of Education, 1964      **A Small Selected Management and Technical Library** John F. Holman & Company, Washington, D.C., 1962      *BLS Report*, 1953      **Ford Dealer and Service Field**, 1937

## Reviewing **Atlas Lathe Operations Manual**: Unlocking the Spellbinding Force of Linguistics

In a fast-paced world fueled by information and interconnectivity, the spellbinding force of linguistics has acquired newfound prominence. Its capacity to evoke emotions, stimulate contemplation, and stimulate metamorphosis is really astonishing. Within the pages of "**Atlas Lathe Operations Manual**," an enthralling opus penned by a highly acclaimed wordsmith, readers attempt an immersive expedition to unravel the intricate significance of language and its indelible imprint on our lives. Throughout this assessment, we shall delve to the book is central motifs, appraise its distinctive narrative style, and gauge its overarching influence on the minds of its readers.

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